

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24043
<b>Description:</b> Reservoir Bottle		<b>Part Number:</b>	✓ 358-044-001
<b>Dwg:</b> N/A		<b>Qty:</b>	2
<b>Ref:</b>		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: Order in multiples of 2</b>	U	05/10/21	2
2	PG	Issue P/O: <u>2008854</u> to Luxfer P/N: L62W-001 Hoop Wrapped Cylinder 6.89" O.D x 20.75" long Volume = 549 cu in Weight = 16.5 lbs Service Pressure = 3000 psi Thread size = 1.125-12 UNF <b>Certificate of conformity is required</b>	A	05/10/21	2
3	RG	Receive and Inspect for transit damage <b>Ensure certificate of conformity is attached</b>	CL	05/11/24	2
4	ST	Identify and Stock in Kwik Float cell	U	05-12-08	2
5	AC	Cost / part _____	SAC	05-12-13	2
6	DC	Close W/O Inspect Level 21	Q	05/12/12	2

Rev	Date	Change	Revised By	Approved
A	03.09.11	New issue	KJ/DS	

**RELEASED**

03.09.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-12-02	3b	Prime & Reint ASD QSD 005	<i>[Signature]</i>	05 12 01	2	<i>[Signature]</i> 05-12-02	<i>[Signature]</i> 05-12-02

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/12/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**Luxfer® Gas Cylinders Composite Cylinder Division***ATTN: LINDA***CERTIFICATE OF CONFORMANCE****CUSTOMER:** Dart Aerospace  
1270 Aberdeen Street  
Hawkesbury ON K6A1K7  
Canada**DATE:** 11/22/05**CUSTOMER P.O. NO. :** 2008854**LUXFER S.O. NO. :** 53304**CUSTOMER DRAWING NO. :** N/A**REV. NO. :** N/A

ITEM	LUXFER PART NO.	REV	SAMPLE PLAN	DESCRIPTION	QUANTITY
1	L62W-001	A	N/A	COMPOSITE CYLINDERS 9.0 Liter / 207 Bar	2

<b>PREFIX:</b>	WS
<b>SERIAL NUMBERS:</b>	5184, 5185

We hereby certify that all materials of construction, processes of manufacture, required inspections and tests meet all applicable specification requirements. Material certifications, inspection and test results are available for review. We also certify that the above listed product items satisfactorily meet all purchase order, drawing and specification requirements for the revisions identified except for the following:

<b>EXCEPTIONS:</b>	NONE
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**SIGNED:****TITLE :** Luxfer Representative**DATE:** 11/22/05**Setting the Standard Worldwide®**

CCD-11-96-33

3016 Kansas Ave.  
Riverside, CA  
92507 USA  
Tel: (909)-684-5110

Date: Monday, 12/5/2005 7:06:23 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : D206590021
<b>Job Number</b> : 25106	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : Z_CUSTOM
<b>This Issue</b> : 12/5/2005	<b>Drawing Number</b> : Z_CUSTOM
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 00015	<b>Material</b> : N/A
<b>Written By</b> :	<b>Due Date</b> : 12/12/2005
<b>Checked &amp; Approved By</b> :	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> :	

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1  
 re-assemble and verify parts from serviceable kit  
 to make D206-590-021

12 05.12.08

Job Completion



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Reservoir Kit, Fwd Mount		<b>Part Number:</b>	<b>D206-590-027</b>
<b>Dwg:</b> 358-07-02 Rev. F		<b>Qty:</b>	<b>1</b>
		<b>Page 1 of 3</b>	

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4	KF	<b>Bottle Assemblies: (Note: Threaded areas to be coated with MIL-C-16173 prior to assembly.</b> Install 358-037-001 bushing with 358-043-001 packing into each bottle and tighten.																																																																																																																																																																															

REFERENCE ONLY

UNDER REVIEW  
 ADA DSI 9308  
 + D3448-1  
 05.07.13

RELEASED

03.10.22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Reservoir Kit, Fwd Mount	<b>Part Number:</b>	<b>D206-590-027</b>
<b>Dwg:</b> 358-07-02 Rev. F	<b>Qty:</b>	<b>1</b>
		<b>Page 2 of 3</b>

Step	Location	Procedure	By	Date	Qty
5	KF	Install MS21926-J12 elbow with AN6289-J12 nut, MS28773-12 back-up ring and MS28778-12 packing. Tighten nut.			
6	KF	<b>Rack Assembly:</b> Drill and ream spigot sleeve to 0.500". Install spigot into Jig SC1842.			
7	KF	Install bottle rack into Jig SC1842. Trim ends of tube and fit 358-025-001 clevis. Drill hole # A in both clevis and tube.			
8	KF	Remove bottle rack from Jig. Remove clevis and keep with rack.			
9	FP	Powder Coat rack White Gloss as per QSI 005 4.3.5.2			
10	QC3	Inspect Powder Coat			
11	KF	Install 358-024-001 spigot into rack with MIL-C-16173, AN960JD816 washer and MS21042L8 nut. Torque nut to 400 inch lb.			
12	KF	Install clevis to rack using AN4-20A bolt, AN960JD416 washer and MS21042L4 nut.			
13	KF	Install 358-032-001 lanyard (2 off) to rack.			
14	KF	Install NAS1335C2C07 pip pin to lanyard.			
15	KF	Install MS27833-6-300 rubber strip onto MS21920-61 bottle clamp. Install bottles onto rack, position clamps, and drill rivet holes through clamps and brackets. Rivet clamps to rack.			
16	QC5	Inspect work to Step 15			
17	KF	<b>Valve Assembly: (Note: All threaded fittings in high pressure area are to be coated with MIL-C-16173 prior to assembly. Torque all AN6289-J12 nuts to 50 ft lb.</b> Deburr 358-036-001 reservoir adaptor internally before installation of fittings.			
18	KF	Install 358-048-001 pressure gauge with AN6289-J4 nut, MS28773-04 back-up ring and MS28778-4 packing. Torque to 80 inch lb.			
19	KF	Install MS28889-2 inflation valve and MS28778-6 packing. Torque to 80 inch lb.			
20	KF	Install 358-047-001 fusible plug and MS28778-6 packing. Torque to 110 inch lb.			
21	KF	Install 358-050-001 relief valve and MS28778-4 packing. Torque to 110 inch lb.			
22	KF	Install (2 off) AN6289-J12 nuts onto 358-036-001 reservoir adaptor with MS28773-12 back-up ring and MS28778-12 packing.			
23	KF	Screw reservoir adaptor into 358-051-001 solenoid valve assembly until nut has full thread contact on adaptor and position adaptor so pressure gauge is positioned to starboard side of helicopter.			
24	KF	Install AS1039J-08-08-12 tee with AN6289-J12 nut, MS28773-12 back-up ring and MS28778-12 packing into solenoid valve assembly and position 90° to valve and tighten nut.			

REFERENCE ONLY

UNDER REVIEW

205-0713

RELEASED

03.0.22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Reservoir Kit, Fwd Mount	<b>Part Number:</b>	<b>D206-590-027</b>
<b>Dwg:</b> 358-07-02 Rev. F	<b>Qty:</b>	<b>1</b>
		<b>Page 3 of 3</b>

Step	Location	Procedure	By	Date	Qty																								
25	KF	Install AN938-J12 tee onto adaptor to give full nut thread contact on adaptor. Install MS21902-J12 union and MS28778-12 packing onto each free end of the tee.																											
26	QC5	Inspect work to Step 25																											
27	KF	<b>Rack and Reservoir Assembly:</b> Attach 358-028-001 LH bracket and 358-029-001 RH bracket to rack using (4 off) AN4-5A bolts, (4 off) AN960JD416 washers and (4 off) MS21042L4 nuts.																											
28	KF	Position the bottles into the rack and install tube between elbow on bottle and tee.																											
29	KF	Install the bottle assembly into the rack assembly by inserting the solenoid valve between the LH and the RH brackets. Attach using (2 off) AN4-24A bolts, (4 off) AN960JD416 washers and (2 off) MS21042L4 nuts.																											
30	KF	Fit 358-078-001 decal to one bottle, same side as pressure gauge.																											
31	QC5	Carry out final inspection																											
32	KP	<b>Pick: Kits</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>358-061-001</td><td>Quick Disconnect</td><td>1 B24029/1 18531</td></tr><tr><td>1</td><td>358-081-001</td><td>Cable Assembly</td><td>in fixed proc kit</td></tr><tr><td>1</td><td>469-056-001</td><td>Hose Assembly</td><td>M18531</td></tr><tr><td>1</td><td>469-057-001</td><td>Hose Assembly</td><td>M18531</td></tr><tr><td>2</td><td>469-058-001</td><td>Hose Assembly</td><td>M18531</td></tr></table>	Qty	Part Number	Description	Batch	2	358-061-001	Quick Disconnect	1 B24029/1 18531	1	358-081-001	Cable Assembly	in fixed proc kit	1	469-056-001	Hose Assembly	M18531	1	469-057-001	Hose Assembly	M18531	2	469-058-001	Hose Assembly	M18531			
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33	QC4	Inspect Kit 100% for Completeness on the W/O																											
34	PK	Identify and pack for shipping as per PPP D206-590-027																											
35	AC	Cost / part																											
36	DC	Close W/O Inspect Level 21																											

Rev	Date	Change	Revised By	Approved
A	03.10.21	New issue	KJ/DS	#

**RELEASED**

03.10.22

UNDER REVIEW

03.09.13

## 2.0 PARTS LIST

Qty -011	Qty -021	Qty -013	Qty -023	Qty -015	Qty -016	Qty -017	Qty -027	Item No.	Part Number	Description
X									D206-590-011	Kwik Float Installation, Cargo Hook Mount
	K								D206-590-021	Kwik Float Installation, Fwd Mount
1	1	X							D206-590-013	Fixed Provisions Kit <i>deck wiring</i>
	1		X						D206-590-023	Fixed Provisions Kit, Fwd Mount <i>mounting kit</i>
1	1			X					D206-590-015	Sponson Kit, LH
1	1				X				D206-590-016	Sponson Kit, RH
1						X			D206-590-017	Reservoir Kit, Cargo Hook Mount
	1						X		D206-590-027	Reservoir Kit, Fwd Mount <i>Bottle rack</i>
		16						5	31885	Terminal
		4						6	31891	Terminal
				1	1			58	35805 (D3232-1)	Doubler
		3						11	320559	Splice
				1	1			8,9	358-001-001	Sponson Tube
				2	2			10	358-003-001 (D3231-1)	Sponson Plug
				6	6			13	358-006-001	Extrusion
				3	3			15	358-008-001 (D3218-041)	Float Assembly
				2	1			16	358-009-001	Float Cover
				1	2			18	358-010-001	Float Cover
	2							19A	358-011-001 (D3228-041)	Fwd Crosstube Bracket
	2							19B	358-011-002 (D3228-042)	Fwd Crosstube Bracket
	2							329A	358-012-001 (D3228-043)	Aft Crosstube Bracket
	2							329B	358-012-002 (D3228-044)	Aft Crosstube Bracket
		4						21	358-013-001A (D3227-1 or DEO 9251)	Crosstube Support
				2	2			22	358-014-001 (D3226-1)	Sponson Support
				4	4			24	358-016-001	Bushing
						1		26	358-018-001	Center Bottle Rack
				4	4			27	358-019-001	Pip Pin
	8							30	358-022-001	Spacer
						1	1	32	358-024-001	Spigot
						2	2	33	358-025-001	Clevis
						1	1	36	358-028-001	Valve Bracket, LH
						1	1	37	358-029-001	Valve Bracket, RH
						2	2	40	358-032-001	Lanyard
						1	1	44	358-036-001	Reservoir Adapter
						2	2	45	358-037-001 (D3229-1)	Bottle Nut
						2	2	51	358-043-001	Packing
						2	2	52	358-044-001	Bottle
						1	1	55	358-047-001	Fusible Plug
						1	1	56	358-048-001	Pressure Gauge
						1	1	59	358-050-001	Relief Valve
						1	1	60	358-051-001	Valve
				3	3			63	358-054-001	Hose Assembly
				3	3			64	358-055-001	Hose Assembly
						2		65	358-056-001	Hose Assembly

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Qty -011	Qty -021	Qty -013	Qty -023	Qty -015	Qty -016	Qty -017	Qty -027	Item No.	Part Number	Description
						2		66	358-057-001	Hose Assembly
						2	2	71	358-061-001	Quick Disconnect
		2						72	358-062-001 (D3225-041)	Coupling Bracket
		1						75	358-065-001	Decal
		1						76	358-066-001	Decal
		1						77	358-067-001	Decal
		1						78	358-068-001	Decal
		1						79	358-069-001	Decal
		1						80	358-070-001	Decal
		1						82	358-072-001 (D3222-1)	Switch Bracket
		1						83	358-073-001 (D3221-041)	Switch Cover
		1						86	358-076-001	Decal
		1						87	358-077-001	Decal
						1	1	215	358-078-001	Decal
		1						89	358-079-001	Decal
						1	1	92	358-081-001	Cable Assembly
		1						94	358-083-001	Cable Assembly
			1					302	469-004-002	Spigot Fitting
			2					303	469-004-003	Clevis Fitting
			1					307	469-004-004	Cable Bracket
			1					309	469-004-005	Cargo Hook Bracket
							1	301	469-010-001	Fwd Bottle Rack
						2	2	43	469-035-002A	Tube Assembly
							1	304	469-056-001	Hose Assembly
							1	305	469-057-001	Hose Assembly
							2	306	469-058-001	Hose Assembly
		8						20/153	5/16WC	Washer
			8					325	80-007-16-3	Insert
				6	6			131	AE81509G	Swivel
			4					310	AN3-6A	Bolt
						4	4	107	AN4-5A	Bolt
						2	2	132	AN4-20A	Bolt
						2	2	133	AN4-24A	Bolt
		4						137	AN5-12A	Bolt
		4						137	AN5-14A	Bolt
		8						137	AN5-34A	Bolt
		8						199	AN5-37A	Bolt
						1	1	139	AN6289-J4	Nut
						5	5	138	AN6289-J12	Nut
			1					319	AN743-12	Clip
				1	1			140	AN816-8D	Fitting
				6	6			143	AN924-6D	Nut
				1	1			323	AN932-4D	Sponson Blank Plug
						1	1	144	AN938-J12	Tee
		2						150	AN960JD4L	Washer
		4						147	AN960JD6L	Washer
		4						145	AN960JD10	Washer
			15					313/327	AN960JD10L	Washer
						10	10	148	AN960JD416	Washer
		16						200	AN960JD516L	Washer
						1	1	152	AN960JD816	Washer
				6	6			N/A	AN970-3	Washer
						1	1	154	AS1039J-08-08-12	Tee

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Qty -011	Qty -021	Qty -013	Qty -023	Qty -015	Qty -016	Qty -017	Qty -027	Item No.	Part Number	Description
						12	12	190	MS20426AD3-6 or M7885/3-4-04	Rivet
		2						164	MS21042L04	Nut
		4						165	MS21042L06	Nut
		4	5					166/316/328	MS21042L3	Nut
						8	8	167	MS21042L4	Nut
		16						170	MS21042L5	Nut
						1	1	171	MS21042L8	Nut
						2	2	146	MS21902-J12	Union
			1					320	MS21919DG-13	Clamp
		4						174	MS21919DG-34	Clamp
						4	4	35	MS21920-61	Bottle Clamp
						2	2	142	MS21926-J12	Elbow
		1						175	MS24523-22	Switch
		1						176	MS24524-26	Switch
				8	8			156	MS24694-S55	Screw
		1						177	MS25224-1	Switch Guard
		1						178	MS26574-5	Circuit Breaker
		4	1					181/326	MS27039-1-08	Screw
			9					312	MS27039-1-09	Screw
				80	80			179	MS27039-1-10	Screw
				20	20			N/A	MS27039-1-13	Screw
						4	4	311	MS27833-6-300	Pad
						1	1	182	MS28773-04	Retainer
						5	5	183	MS28773-12	Retainer
				4	4			184	MS28775-039	Packing
						2	2	186	MS28778-4	Packing
				6	6	2	2	187	MS28778-6	Packing
						7	7	185	MS28778-12	Packing
						1	1	189	MS28889-2	Charging Valve
						1	1	191	MS3126F10-6P	Connector
			1					322	MS3181-10N	Cap
			1					321A	MS3416-10EN	Shell
			1					321B	MS3474W10-6S	Connector
		2						192	MS35206-217	Screw
		2						209	MS35214-25	Screw
		2						193	MS35214-28	Screw
							2	308	MS35489-19	Grommet
		1						195	MS35489-33	Grommet
		2						198	NAS43DD0-16	Spacer
				106	106			196	NAS1330C3KB166	Rivnut
						2	2	197	NAS1335C2C07	Pip Pin

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